

# HiFill® PA6/6 GB20 L

Polyamide 66

Techmer Engineered Solutions

## Message:

HiFill® PA6/6 GB20 L is a polyamide 66 (nylon 66) product containing 20% glass beads. It can be processed by injection molding and is available in North America.

Features include:

flame retardant/rated flame

Lubrication

| General Information                 |                                   |                   |             |
|-------------------------------------|-----------------------------------|-------------------|-------------|
| Filler / Reinforcement              | Glass beads, 20% filler by weight |                   |             |
| Additive                            | Lubricant                         |                   |             |
| Features                            | Lubrication                       |                   |             |
| Forms                               | Particle                          |                   |             |
| Processing Method                   | Injection molding                 |                   |             |
| Physical                            | Nominal Value                     | Unit              | Test Method |
| Specific Gravity                    | 1.28                              | g/cm <sup>3</sup> | ASTM D792   |
| Molding Shrinkage - Flow (3.18 mm)  | 1.5                               | %                 | ASTM D955   |
| Water Absorption (24 hr)            | 0.90                              | %                 | ASTM D570   |
| Hardness                            | Nominal Value                     | Unit              | Test Method |
| Rockwell Hardness (R-Scale)         | 119                               |                   | ASTM D785   |
| Mechanical                          | Nominal Value                     | Unit              | Test Method |
| Tensile Strength (Break)            | 75.8                              | MPa               | ASTM D638   |
| Tensile Elongation (Break)          | 3.5                               | %                 | ASTM D638   |
| Flexural Modulus                    | 4140                              | MPa               | ASTM D790   |
| Flexural Strength                   | 117                               | MPa               | ASTM D790   |
| Impact                              | Nominal Value                     | Unit              | Test Method |
| Notched Izod Impact (23°C, 3.18 mm) | 32                                | J/m               | ASTM D256   |
| Unnotched Izod Impact (3.18 mm)     | 200                               | J/m               | ASTM D256   |
| Thermal                             | Nominal Value                     | Unit              | Test Method |
| Deflection Temperature Under Load   |                                   |                   | ASTM D648   |
| 0.45 MPa, not annealed              | 232                               | °C                | ASTM D648   |
| 1.8 MPa, not annealed               | 177                               | °C                | ASTM D648   |
| Melting Temperature                 | 255                               | °C                |             |
| CLTE - Flow                         | 5.9E-5                            | cm/cm/°C          | ASTM D696   |
| Electrical                          | Nominal Value                     | Unit              | Test Method |
| Volume Resistivity                  | 1.0E+14                           | ohms · cm         | ASTM D257   |
| Dielectric Strength <sup>1</sup>    | 16                                | kV/mm             | ASTM D149   |
| Flammability                        | Nominal Value                     | Unit              | Test Method |
| Flame Rating (1.50 mm)              | HB                                |                   | UL 94       |

#### Injection instructions

Screw Speed: Medium Recommendations for Molding and Tool Conditions: Well vented Moisture Content, as received: Product is packaged at 0.2% or less. Recommended Max Moisture: 0.12% down to 0.08%

#### NOTE

1. Method A (short time)

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